



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-591-311
Job Sheet 186614



Part No: D350-591-311

Job Qty: 20 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/19/18

Job Tracking No: AIRBUS

Due Date: 12/21/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		12/21/18	0.00	0.00	Start Up Large Fab-4		SLU
110	Large Fab	10 pcs		12/21/18	0.00	9.91	Large Fab 2		SLU
120	QC	10 pcs		12/21/18	0.00	0.00	QC9		CPC
130	QC	10 pcs		12/21/18	0.00	0.00	QC5		CPC
140	HandFinish	10 pcs		12/21/18	0.00	1.84	HandFinish1		DR 18/11/28
150	QC	10 pcs		12/21/18	0.00	0.00	QC7-2		CPC
180	Large Fab	10 pcs		12/21/18	0.00	9.91	Large Fab 2		SLU
190	QC	10 pcs		12/21/18	0.00	0.00	QC10		38 DAS
200	QC	10 pcs		12/21/18	0.00	0.00	QC5		38 9-89
210	HandFinish	10 pcs		12/21/18	0.00	1.84	HandFinish1		DR 18/12/14
220	Powdercoat	10 pcs		12/21/18	0.00	2.90	Powdercoat1		BR 18-12-4
230	HandFinish	10 pcs		12/21/18	0.00	1.84	HandFinish3		BEB 18-12-05
240	QC	10 pcs		12/21/18	0.00	0.00	QC3		DEC 07 2018 68
250	Packaging	10 pcs		12/21/18	0.00	0.00	Packaging1-3		DEC 17 2018 9-89
260	QC	10 pcs		12/21/18	0.00	0.00	QC4		46 DAS DEC 20 2018
270	Packaging	10 pcs		12/21/18	0.00	0.00	Packaging3-1		46 DEC 20 2018
275	DC	10 pcs		12/21/18	0.00	0.00	DC		21 9-89 DEC 20 2018
280	QC21-FG	10 Ea		12/21/18	0.00	0.00	QC21		21 DEC 20 2018

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod M13475 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 10:25 OVEN TEMPERATURE: 300 FINISH TIME: 11:55

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG109

275 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

wing walk M138 963

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 Ea (2 ea)	90-Start up Operation	5113595 / 5125543
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	5125734
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	5129516

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

D3065-041	Step Leg Assembly	9 10 Ea (1 ea)	180-Large Fab
D3066-1	Spacer	18 20 Ea (2 ea)	180-Large Fab
MS20600-AD4W4	Rivet	144 160 Ea (16 ea)	180-Large Fab
AN3-35A	Bolt	18 20 Ea (2 ea)	250-Packaging
AN4-13A	Bolt	72 80 Ea (8 ea)	250-Packaging
AN5-36A	Bolt	18 20 Ea (2 ea)	250-Packaging
D2230-3	Mounting Lug	36 40 Ea (4 ea)	250-Packaging
D2618	Bushing	18 20 Ea (2 ea)	250-Packaging
D2856-400-720	Abrasion Strip 4" X 7.20"	18 20 Ea (2 ea)	250-Packaging
D3235-1	Mounting Lug	18 20 Ea (2 ea)	250-Packaging
D3278-041	Support Assembly	9 10 Ea (1 ea)	250-Packaging
MS21042L3	Nut	18 20 Ea (2 ea)	250-Packaging
MS21042L4	Nut	72 80 Ea (8 ea)	250-Packaging
MS21042L5	Nut	18 20 Ea (2 ea)	250-Packaging
NAS1149D0363J	Washer	36 40 Ea (4 ea)	250-Packaging
NAS1149D0463J	Washer	144 160 Ea (16 ea)	250-Packaging
NAS1149D0563J	Washer	36 40 Ea (4 ea)	250-Packaging

① 5127961 ② 5132648

5129757
5117999
5101329
5115326
5099504
5137811
5137950 x2 5118035 x16
5104554
5113205
5118822
5094592
5112434
5093592
5107782
5092780
5050053

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	20	260	0
	D3219-1	20	219	0
	D3272-1	10	1	0
180-Large Fab	D3065-041	10	21	0
	D3066-1	20	350	0
250-Packaging	MS20600-AD4W4	160	2,558	0
	AN3-35A	20	253	0
	AN4-13A	80	950	0
	AN5-36A	20	116	0
	D2230-3	40	68	0
	D2618	20	169	0
	D2856-400-720	20	186	0
	D3235-1	20	109	0
	D3278-041	10	43	0
	MS21042L3	20	1,721	0
	MS21042L4	80	1,882	0
	MS21042L5	20	423	0
	NAS1149D0363J	40	2,068	0
	NAS1149D0463J	160	2,662	0
	NAS1149D0563J	40	1,308	0

Part Specifications

Specifications could not be found.

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Plex 11/19/18 10:30 AM Dart.lajeunesse.marie

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

REFERENCE ONLY

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Revision: I

Date: 18.05.25

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